

Date: Wednesday, 9/26/2007 2:09:19 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	SEAT PAN
Job Number	34897		
Estimate Number	11092		
P.O. Number	:	Part Number	D30221
This Issue	9/26/2007	Drawing Number	D3022 REV A
Prsht Rev.	NC	Project Number	N/A
First Issue	/ /	Drawing Revision	A
Previous Run	33366	Material	:
Written By		Due Date	10/15/2007
Checked & Approved By	<u>PD 07.09.26</u>	Qty:	1 Um: Each
Comment	Est. C 02.01.23 Revised NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet
		Comment: Qty.: 1.7044 sf(s)/Unit Total : 1.7044 sf(s) 2024-T3 .032 sheet Material: 2024-T3 sheet (QQ-A-250/4) 0.032" Batch: M105555
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		Comment: LARGE FABRICATION RESOURCE 1 1-Cut seat pan (32.00" x 14.75") as per template D3022-1T1 & Dwg D3022.
3.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP
4.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE Form as per Dwg D3022
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		Comment: LARGE FABRICATION RESOURCE 1 1-Transfer drill Seat Pan From Frame
		Comment: 2-Deburr
		Comment: PD 08-04-15
		Comment: SB 08/04/16
		Comment: SB 08/04/16
		Comment: PD 08-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

307000/2008
S.055 06.07

B1 325.7
B2 34894
B3 30221
B4 -----

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT PAN

Job Number: 34897

Part Number: D30221

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS/04/17

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FZ 08/04/17 ①

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 106442

BL 08-04-18 ④

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 08/04/23 ①

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 08/04/23 ①

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/24 ④

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

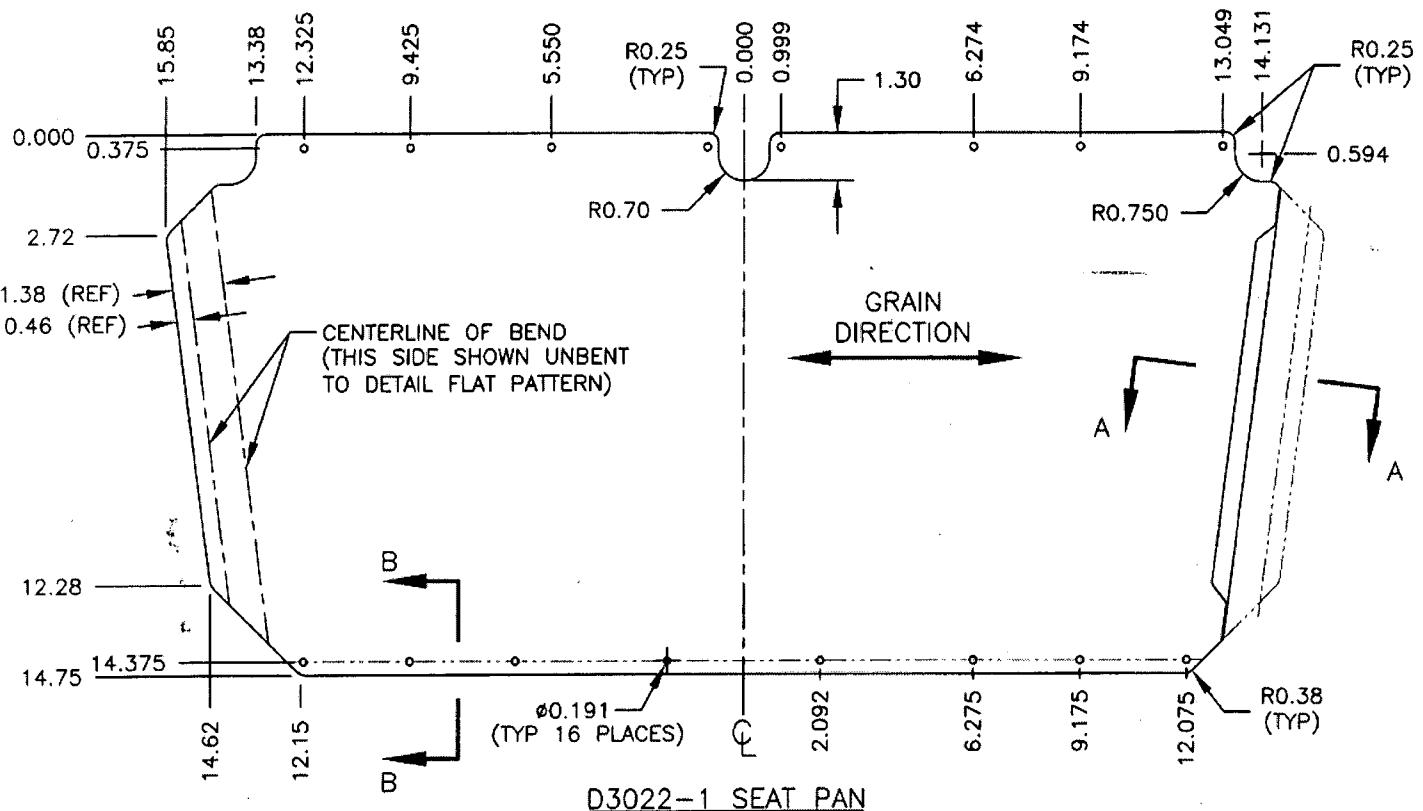
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

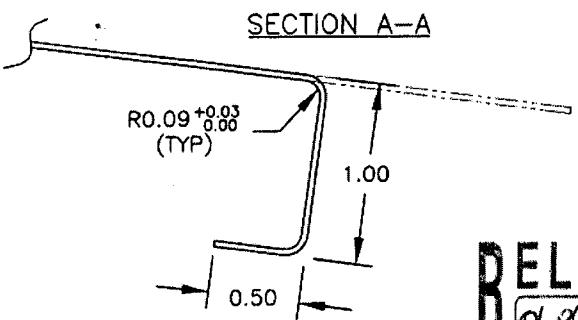


DART

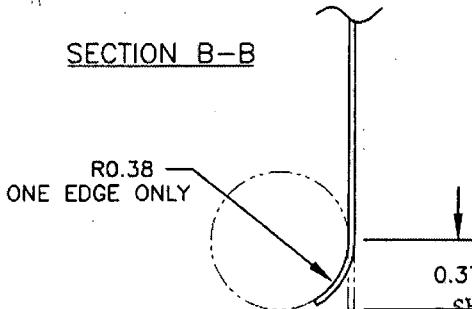
DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D3022	REV. A SHEET 1 OF 1	
DATE 01.05.18		TITLE SEAT PAN	SCALE 1:5	
A	01.05.18	NEW ISSUE		



SECTION A-A



SECTION B-B



NOTES:

- 1) SHAPE IS SYMMETRIC ABOUT CENTERLINE, HOLE PATTERN IS NOT
 - 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
 - 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WITHOUT
WORK ORDER

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